

ISS-MPLM-PLAN-019
Revision BASIC
February 3, 2003

PRESSURIZED CARRIERS Group



EXPORT ADMINISTRATION REGULATIONS (EAR) CONTROLLED DATA

Multi Purpose Logistics Module

Quality Plan



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Pressurized Carriers/MPLM Project			
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Signature Page

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REGULATIONS (EAR) CONTROLLED DATA

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DOCUMENT HISTORY LOG

Status (Baseline/ Revision/ Canceled)	Document Revision	Effective Date	Description
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1.0 PURPOSE / SCOPE

The purpose of this plan is to specify the Quality Assurance approach to implementing the MSFC Quality System as defined in MPD 1280.1, "Marshall Management Manual" and associated implementing documentation for the Multi Purpose Logistics Module (MPLM) sustaining engineering projects developed In-House. This plan addresses the quality approach at MSFC for receiving inspection, assembly and test activities associated with the design, development and checkout of hardware needed to replace existing equipment on the MPLM. Applicable MSFC procedures and work instructions are reference documents which will be complied with. This plan is intended to be compliant with the requirements of the Pressurized Carriers, (FD24), Implementing Plans for sustaining engineering, such as, "MPLM Thermostat Development Plan", ISS- MPLM-Plan-017 and future work of the same nature. Overall, the Pressurized Carriers group will structure sustaining efforts under the overall guidelines set forth by ISS-MPLM-Plan-15, "MPLM Sustaining Engineering Plan."

2.0 APPLICABLE DOCUMENTS

NPG 7120.4B	Program/Project Management
NPG 7120.5A	Program & Project Management Process and Requirements
MPD 1280.1	Marshall Management Manual
MPG 1050.1	Contract (Customer Assessment) Review
MPG 1280.2	Process Control
MPG 1280.4	MSFC Corrective Action System
MPG 1280.6	Internal Quality Audits
MPG 1410.2	Marshall Management Directives System
MPG 1440.2	Marshall Records Management Program
MPG 3410.1	Training
MPG 4000.1	Control of Customer-Supplied Product
MPG 4000.2	Property Management
MPG 5000.1	Purchasing
MPG 6410.1	Handling, Storage, Packaging, Preservation and Delivery
MPG 8040.1	Configuration Management, MSFC Programs/Projects
MPG 8040.2	Product Identification
MPG 8040.3	Product Traceability
MPG 8060.1	Flight Systems Design/Development Control
MPG 8730.1	Inspection & Testing
MPG 8730.2	Inspection & Test Status
MPG 8730.3	Control of Non-Conforming Product
MPG 8730.4	Statistical Techniques
MPG 8730.5	Control of Inspection, Measuring and Test Equipment
MWI 1280.3	Corrective/Preventive Action Notification System

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MWI 1280.5	MSFC Alert Processing
MWI 5100.1	Procurement Initiator's Guide
MWI 5113.1	Government-wide Commercial Purchase Card Operating Procedures

ISS-MPLM-Plan-015 MPLM Sustaining Engineering Plan

MSFC-Std-3012 EEE Parts Man Account and Control for MSFC Hardware

FD24-CM01	Pressurized Carriers Group Configuration Management Plan
QS-QA-001	Acceptance Reporting Instruction
QS-QA-003	Quality Assurance Guidelines for Test Activities
QS-QA-008	Review of Work Authorizing Documents
QS-QE-001	Project Quality Instruction
QS-QE-003	Participation in Space Flight Program/Project Baseline Design Review
	Program

3.0 **DEFINITIONS**

Quality Sensitive - A term applied to MSFC procurement requests to identify flight hardware and flight associated ground support equipment. This term applies to those items that are to be assembled into a launch vehicle and associated equipment for testing, handling, launching, and maintaining a vehicle in space. This term also applies to qualification and re-qualification hardware. Hardware that is procured for development testing is not quality sensitive unless the data resulting from development activities will be used in the "justification for qualification" of flight hardware or flight associated hardware or is used in a hazardous operation.

<u>Count and Condition</u> – An inspection, usually conducted upon receipt, performed to verify that the quantity ordered has been received, and to verify that the shipping container and contents have not been damaged in transit.

<u>Deviation Approval Request (DAR)</u>- A specific request to depart from a baselined performance or design requirement of a specification, drawing or other document for a specific number of units or a specified time period. DAR's differ from an engineering change in that an approved engineering change requires corresponding revision of the documentation defining the affected item, whereas the DAR does not contemplate revision of the applicable specification or drawing. DAR's shall be filled out using the MSFC Form 847.

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4.0 ACRONYMS

ADP	Acceptance Data Package
CoC	Certificate of Compliance
COTS	Commercial Off the Shelf
CSP	Customer-Supplied Product
DAR	Deviation Approval Request
EEE	Electronic, Electrical, and Electromechanical
GSE	Ground Support Equipment
IM	Isolation Mode
IPT	Integrated Product Team
MPLM	Multi-Purpose Logistics Module
MQM	MSFC Quality Manual
MSFC	Marshall Space Flight Center
PC	Pressurized Carriers
PCB	Printed Circuit Board
PIND	Particle Impact Noise Detection
PWA	Printed Wiring Assembly
PWB	Printed Wiring Board
QA	Quality Assurance
QAR	Quality Assurance Representative
QMS	Quality Management System
S&MA	Safety and Mission Assurance
RVC	Requirements, Verification, and Compliance
WAD	Work Authorizing Document

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5.0 QUALITY SYSTEM Requirements

5.1 Management Responsibilities.

The MPLM Element Manager is responsible for ensuring the quality assurance requirements set forth by this document are understood, implemented, and maintained at all organizations participating in the Pressurized Carriers (PC) Group Projects, as specified in document NPG 7120.4B "Program/Project Management" and NPG 7120.5A, "Program and Project Management Process and Requirements".

5.2 Quality System.

The MPLM Element Manager and the Cargo Assurance Department (QS30) / Quality Assurance Representative (QAR) will be responsible for the implementation of the MSFC ISO Quality Management System (QMS).

5.3 Contract Review.

Customer Agreement(s) will be reviewed in accordance with MPG 1050.1, "Contract (Customer Agreement) Review." The customer agreement(s) is a quality record(s) that will be maintained and controlled by the MPLM Element Manager (FD24) as specified in ISS-MPLM-Plan-015, "MPLM Sustaining Engineering Plan", Par 4.1.4.3.

5.4 Design Review.

Design Control will be accomplished in accordance with MPG 8060.1 and MPG 8040.1. The type and number of Design Reviews will be specified in the appropriate Development Plan. Specific requirements for documentation review and approval are defined in the PC Group Configuration Management Plan (FD24-CM01).

Reviews of drawings will be performed by the QS30 QAR to the requirements of "Project Quality Inspection" (QS-QE-001 and), "Review of Work Authorizing Documents (QS-QA-018). The QAR will support the design review to the requirements of QS01-QE-003, "Participation in Space Flight Program / Project Baseline Design Review Process".

Configuration Management requirements defined in MPG 8040.1 will be implemented by the "PC Group Configuration Management Plan" (FD24-CM01)

5.5 <u>Document and Data Control.</u>

Documentation and data control will be accomplished in accordance with MPG 1410.2, "Marshall Management Directives System". Hardware designs will be controlled by End Item Specifications.

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5.6 Purchasing.

Procurements will be reviewed to the requirements of MPG 5000.1, "Purchasing," and MWI 5100.1 "Procurement Initiator's Guide." All purchase requests for items considered "Quality Sensitive" will be reviewed by the project QAR, to the requirements of QS-QE-001, "Project Quality Instruction." Minimum requirements for receiving of Quality Sensitive items will be "Count and Condition" inspection. Credit Card purchases for flight hardware will be done in accordance with MWI 5113.1, Governmentwide Commercial Purchase Card Operating Procedures. Coordination of inspection and test activities between MSFC and their subcontractor will be identified in the procurement documentation.

Control of Customer-Supplied Product. 5.7

Control of Customer-Supplied Product (CSP) will be in accordance with MPG 4000.1, "Control of Customer-Supplied Product".

- Product Identification and Traceability 5.8
- Product Identification. Identification will be in accordance with MPG 8040.2, "Product Identification".
- 5.8.2 Product Traceability. Traceability will be in accordance with MPG 8040.3, "Product Traceability". EEE Parts will be controlled in accordance with MSFC-STD-3012, "EEE Parts Management and Control for MSFC Space Flight Hardware". Level of part and material traceability will be defined by the Project and will be flowed into the engineering and Engineering Parts Lists by the responsible organization.

A waiver will be requested from the JSC EEE Parts Board to use industrial grade EEE parts.

MPLM hardware development activities will use MSFC ALERT system to track potential nonconformances related to parts, components, and manufacturing processes, per MWI 1280.5, "MSFC Alert Processing."

5.9 Process Control.

Process will be controlled in accordance with MPG 1280.2, "Process Control".

Inspection and Test.

Inspection and testing will be performed per MPG 8730.1, "Inspection and Testing" and as specified below.

5.10.1 Receiving Inspection and Nonconformance Feedback. Receiving inspection will be performed by the QS30/QA. Results of quality inspection will be documented per QS-QA-001, "Acceptance Reporting Instruction", and MPG 4000.2, "Property Management". Specific quality requirements for receiving inspection and test are documented in Appendix A.

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Items found nonconforming and accepted by the NASA contracting officer will be documented and dispositioned to the requirements of MPG 8730.3, "Control of Nonconforming Product," prior to further processing.

- 5.10.2 <u>In-process Inspection and Test</u>. In-process inspection and test performed at MSFC will be specified in the approved, controlled Work Authorizing Documents (WADs) and will be performed in accordance with approved procedures. Prior to performing test, the test documents will be reviewed by QA in accordance with QS-QA-003, "Quality Assurance Guidelines for Test Activities."
- 5.10.3 Final Inspection and Test. Final inspection and test performed at MSFC will be specified in the approved, controlled WADs and will be performed in accordance with approved plans and procedures. Prior to performing a test, the test documents will be reviewed by QA in accordance with QS-QA-003.
- 5.10.4 <u>Inspection and Test Records</u>. Inspection and test records required by the PC's project for verification and/or flight certification requirements will be specified or identified in the appropriate End Item Specification and kept as quality records as per MPG 8730.1, MPG 8730.2, and QS-QA-014.
- Control of Inspection, Measuring, and Test Equipment. 5.11

The control of inspection, measuring and test equipment used to characterize and/or accept inscope Flight, and Flight associated hardware and software will meet the requirements of MPG 8730.5, "Control of Inspection, Measuring, and Test Equipment".

Inspection and Test Status.

Inspection status/stamp control will be to the requirements of MPG 8730.2, "Inspection and Test Status".

Control of Nonconforming Product. 5.13

Nonconforming article and material control will be as specified in MPG 8730.3, "Control of Nonconforming Product".

- Corrective and Preventive Action. 5.14
- 5.14.1 Corrective Action. Corrective Action will be in accordance with MPG 1280.4, "MSFC Corrective Action System".
- 5.14.2 Corrective/Preventive Action. Corrective/Preventive Action will be in accordance with MWI 1280.3, "Corrective/Preventive Action Notification System".

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5.15 Handling, Storage, Packaging, Preservation and Delivery.

Handling, storage, preservation, marking, labeling, packaging, and shipping will be to the requirements of MPG 6410.1, "Handling, Storage, Packaging, Preservation, and Delivery" and as specified in Appendix A.

5.16 Control of Quality Records.

All submitted Quality Records for the PC Group will be retained by the PC/MPLM Element Manager in accordance with MPG 1440.2, "MSFC Records Management Program".

The Quality Records generated by the QS30/QA, will be maintained as specified in QS-QA-014, "Quality Assurance Records Center". All data items should be addressed to "Quality Records Center (QS30), PC's Group File." QS30 will deliver data packages as copies of the original submitted documentation. They will be itemized as specified by the PC Group. Upon completion of the project the original data will be delivered as specified by the PC Group.

5.17 Internal Quality Audits.

Internal quality audits will be performed to the requirements of MPG 1280.6, "Internal Quality Audits". Internal audits for this program will be scheduled based on the status and importance of the activity to be audited. Audits will be performed by qualified personnel independent of those having direct responsibility for the activity being audited. The results of audits will be recorded and provided to those having responsibility, and timely corrective action provided for discrepancies/deficiencies identified.

5.18 Training.

Training will be in accordance with MPG 3410.1, "Training".

5.19 Servicing.

Servicing not applicable in accordance with MPD 1280.1.

5.20 <u>Statistical Techniques.</u>

Statistical Techniques will be in accordance with MPG 8730.4, "Statistical Techniques".

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APPENDIX A

Pressurized Carrier's Project Hardware Quality Requirements

The Pressurized Carrier's Group (FD24) Sustaining Engineering In-House Projects will certify flight hardware using appropriate Qualification Test Plans. The following list specifies the level of involvement of the MSFC Cargo Assurance Department/QS30 during the design, receiving, fabrication, assembly, and testing process:

- 1. Credit card purchases for flight and related hardware items associated with PC's Hardware will be purchased in accordance with MWI 5113.1, "Government-wide Commercial Purchase Card Operating Procedures".
- 2. Certificates of Compliance (CoC) and a Count and Condition Inspection are the minimum accepted in accordance with QS-QE-001. Inspection and QA monitoring will be at the sub-component level of testing and /or assembly. Storage of flight parts for PC Group's Hardware will be done by the designated MSFC contractor.
- 3. Particle Impact Noise Detection (PIND) and x-ray testing will be performed as required.
- 4. Incoming, blank printed circuit boards (PCBs) will require QS30/QA inspection.
- 5. Before final assembly of the electronics boxes, QS30/QA will visually inspect all connectors and the PCB installations. This inspection will include workmanship requirements performed on the assembled PCBs for soldering, conformal coating, parts routing and staking. These inspections will be in accordance with MPG 1280.2, "Process Control".
- 6. Inspection status will be maintained by QS30/QA from receipt through shipment in accordance with QS-QA-001, "Acceptance Reporting Instruction".
- 7. QS30/QA will review all test procedures in accordance with QS-QA-003, "Quality Assurance Guidelines for Test Activities".
- 8. QS30/QA will monitor all testing in accordance with QS-QA-003, "Quality Assurance Guidelines for Test Activities".

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APPENDIX B:

Acceptance Data Package (ADP) Requirements, typical for in house development responsibility.

Acceptance Data Package

Responsibility

Complete Shipping Documents, DD250 or equivalent Identification Configuration Inspection Review Historical Data
All Program Waivers, Deviations or Exceptions

Unexplained Anomalies

Ship Short Items

Open Paper Open Work

Drawings

LOLI Or Age Sensitive Items

Operating Time/Cycle Data

Installed Non-Flight Items

Proof Load Certifications

Certificate of Cleanliness

Material Certifications (MUA/MIUL)

Phase III Ground Safety Issues

Material Safety Data Sheet

Reliability Data

Safety Data

Hazard Reports

Weight & CG

Logistics

ABCL

Repair Procedures/ Repair Limitations

SW Documentation

Nonflight Hardware/Temporary Installations

Customer Procedures/KSC Procedure Inputs

Verification Data

Verification Tracking Log (Specifications)

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APPENDIX C:

Quality Deliverables

- 1. Pressurized Carriers Group MPLM Project Quality Plan
- 2. MSFC Project Specific Vendor Evaluation Survey and Approval Sheet required as needed
- 3. Pressurized Carriers Group MPLM Project 'As-Built Configuration Status' Required upon completion of Project Specific Element for Pre-Shipment Review

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14. SPECIAL INSTRUCTIONS:												
Index, File and distrubute	per list att	tached for	r Baseli	ne Pressurized	Carr	iers Gro	oup (PC) Multi Po	ourpos	se Logistics N	/Iodule	(MPLM)
15. CONTRACTOR/SUBMITTIN MSFC	15. CONTRACTOR/SUBMITTING ORGANIZATION, ADDRESS AND PHONE NUMBER: 16. ORIGINATING NASA CENTER: MSFC MSFC											
						17. OFFIC Allen Sl		IMARY RESF FD24	PONSI	BILITY:		
18. PROGRAMMATIC CODE (5	DIGITS): 4	77-72-61						19. NUMBE	ROF	PAGES:	tto	18
			11.	ENGINEERI	NG	DRAW	INGS	<u> </u>				
20. REVISION:	21	. ENGINEE	RING OR	DER:	22. 1	PARTS LI	ST:			23. CCBD:		
Basic			NA		N/A				MP3-00-0031			
			III. RE	PORTS, SPE	CIF	ICATIO	,					
24. REVISION:	25. CHANG	·E:		26. VOLUME:			27. BOC	28. P		PART:	29.	SECTION:
30. ISSUE:	31. ANNEX:			32. SCN:			33. DCN:			34. AMEN	IDMENT	:
35. APPENDIX:	36. ADDEN	DUM:		37. CCBD:			38. COE	DE ID:		39. IRN:	··	
				MP3-00	-003	31						
		IV. E	XPORT	AND DISTRI	BU	TION R	RESTRI	CTIONS				
Privacy Act (see MW	VI 1382.1)			🗷 EAR (s	see N	/PG 222	0.1)					
Proprietary (see MP	· ·						•	and MPG 1	600.1))		
☐ Patent (see MPG 22	20.1)			┌┐ No sta	tutor	y or insti	tutional r	estrictions a	applica	able material	may be	е
☐ ITAR (see MPG 222	0.1)			□ electro	onica	lly distrib	outed to u	ser in the N	NASA	domain		
		V. (ORIGIN	IATING ORGA	ANIZ	ZATION	N APPE	ROVAL				
40. ORG. CODE:	41. PHONE	NUMBER:		42. NAME:			<u> </u>	43.,8	SIGNAT	TUPE/DATE:		
FD24	(256	5) 544-355	59	Randy K.McC	LEN	NDON		ya	ndy.	KM(ECleu	da	6F6503
	VI. TO	BE COM	/IPLET	ED BY MSFC	DO	CUME	NTATI	ON REPO	osit	ORY		
44. RECEIVED BY:			Λ	Day	,]	45. DAT	TE RECEI	VED:		46. WOF		
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